

ABSTRACT

5 The invention provides a rolling method for a
flat-rolled metal material and a rolling apparatus for
the method each capable of stably producing a flat-rolled
metal material free from camber or having an extremely
light camber. The method is a rolling method of a flat-
rolled metal material executed by using a rolling mill
including at least work rolls and backup rolls. The
10 apparatus is a rolling mill for this method. A rolling
direction force acting on roll chocks on the operator
side and the driving side of the work roll is measured,
the difference of the rolling direction force between the
operator side and the driving side is calculated and a
15 left-right swivelling component of roll gap of the
rolling mill is controlled on the basis of this
difference.